

Work Order ID 142126

142126

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*Friday, February 26, 2016 3:45:15 PM

① Stock ① Ship 03/02

Item ID: DSI 9645-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Stub Cover Installation Assembly
 Start Date: 2/29/2016 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 3/2/2016 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan MS Date: 16-2-26 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
DSI 9645	A	MLJ							MLJ 16-02-28
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP DSI9645-011 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MAR 01 2016

MAR 01 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 142126***142126***

Page 2

Friday, February 26, 2016 3:45:15 PM

Item ID: DSI 9645-011 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Stub Cover Installation Assembly
Start Date: 2/29/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 3/2/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				2	5m11		
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI9645-011 Location: _____								
			Sold W 8/23/16						
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MCS MAR 01 2016

MCS MAR 01 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

Friday, February 26, 2016 3:45:19 PM

142126

DSI 9645-011

Required Date: 3/2/2016

Required Qty: 2.00

Comments: IPP REV:A 13.03.13 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4778-1 *D4778-1* Stub Cover		Manufactured	No			110	Each	2.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST224B		2							
				136726		2							
D4779-041 *D4779-041* Aft Cover Mounting Bracket Assembly		Manufactured	No			110	Each	3.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST125		3							
				140245		3							
D4780-041 *D4780-041* Fwd Cover Mounting Bracket Assembly		Manufactured	No			110	Each	5.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST125		5							
				140150		5							
MS35207-263 *MS35207-263* Screw		Purchased	No			110	Each	108.0000	8	16			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST271		108							
				m123031		8							
				m134039		100							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Picklist Print

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Work Order ID: 142126

142126

Parent Item: DSI 9645-011

DSI 9645-011

Parent Item Name: Stub Cover Installation Assembly

Start Date: 2/29/2016

Required Date: 3/2/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0363J

Purchased

No

110

Each

1,091.000

8

16

NAS1149D0363J

Washer

**

MLJ

16-02-29

Location

Loc Qty

Loc Code

GA

64

m130799

64

ST263

1027

m133932

27

m134055

1000

DAS
27
8-88

X2

DAS
28
8-88

16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-616 Rev C
 REF CANADIAN STC: SH96-10
 REF FAA STC: SR00405NY
 REF DANISH STC: 27/96 AND 28/96
 REF UK CAA STC: 28097
 REF DGAC FRANCE STC: 84-SI0995 AND 168-SI0996
 REF BRAZILIAN STC: 2013S02-03

1.0 PURPOSE:

THE PURPOSE OF THIS SERVICE INSTRUCTION IS TO OUTLINE THE PROCEDURE FOR REPLACING THE D3494-1 STUB COVER WITH THE D4778-1 STUB COVER BY INSTALLING THE DSI 9645-011 KIT. THE D4778-1 COVER IS DESIGNED TO ELIMINATE THE POTENTIAL FOR INTERFERENCE WITH THE PEDAL STUBS ON SOME AIRCRAFT AND WILL BE INCLUDED IN D350-616-011 KITS AT CHG 005 AND LATER.

2.0 INSTALLATION:

- 2.1 FOR EASE OF INSTALLATION, REMOVE THE D3179-041 LITTER TIE DOWN.
- 2.2 REMOVE THE D3494-1 STUB COVER AND HARDWARE, IF REQUIRED.
- 2.3 PICKING UP ON THE SAME MOUNTING HOLES, INSTALL THE FWD (D4780-041) AND AFT (D4779-041) MOUNTING BRACKETS USING MS35207-263 SCREWS (QTY 4) AND NAS1149D0363J WASHERS (QTY 4).
- 2.4 SLIDE THE D4778-1 STUB COVER OVER THE COVER BRACKETS AND FASTEN WITH MS35207-263 SCREWS (QTY 4) AND NAS1149D0363J WASHERS (QTY 4).
- 2.5 RE-INSTALL THE D3179-041 LITTER TIE DOWN.

NOTE: IT IS PERMISSABLE TO TRIM THE COVER EDGE, AS REQUIRED, FOR CLEARANCE OVER DECK PLATES

3.0 PARTS LIST

QTY -011	P/N	DESCRIPTION
X	DSI 9645-011	STUB COVER INSTALLATION KIT
1	D4778-1	STUB COVER
1	D4779-041	AFT COVER MOUNTING BRACKET ASSY
1	D4780-041	FWD COVER MOUNTING BRACKET ASSY
8	MS35207-263	SCREW
8	NAS1149D0363J	WASHER

4.0 WEIGHT AND BALANCE

INSTALLATION OF THE DSI 9645-011 STUB COVER INSTALLATION HAS NEGLIGIBLE EFFECT ON WEIGHT AND BALANCE.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 13.03.06
CERT. NO.: SH96-10
ISSUE NO.: # 2

A	NEW ISSUE	DB	13.03.06
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9645	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STUB COVER INSTALLATION	NTS
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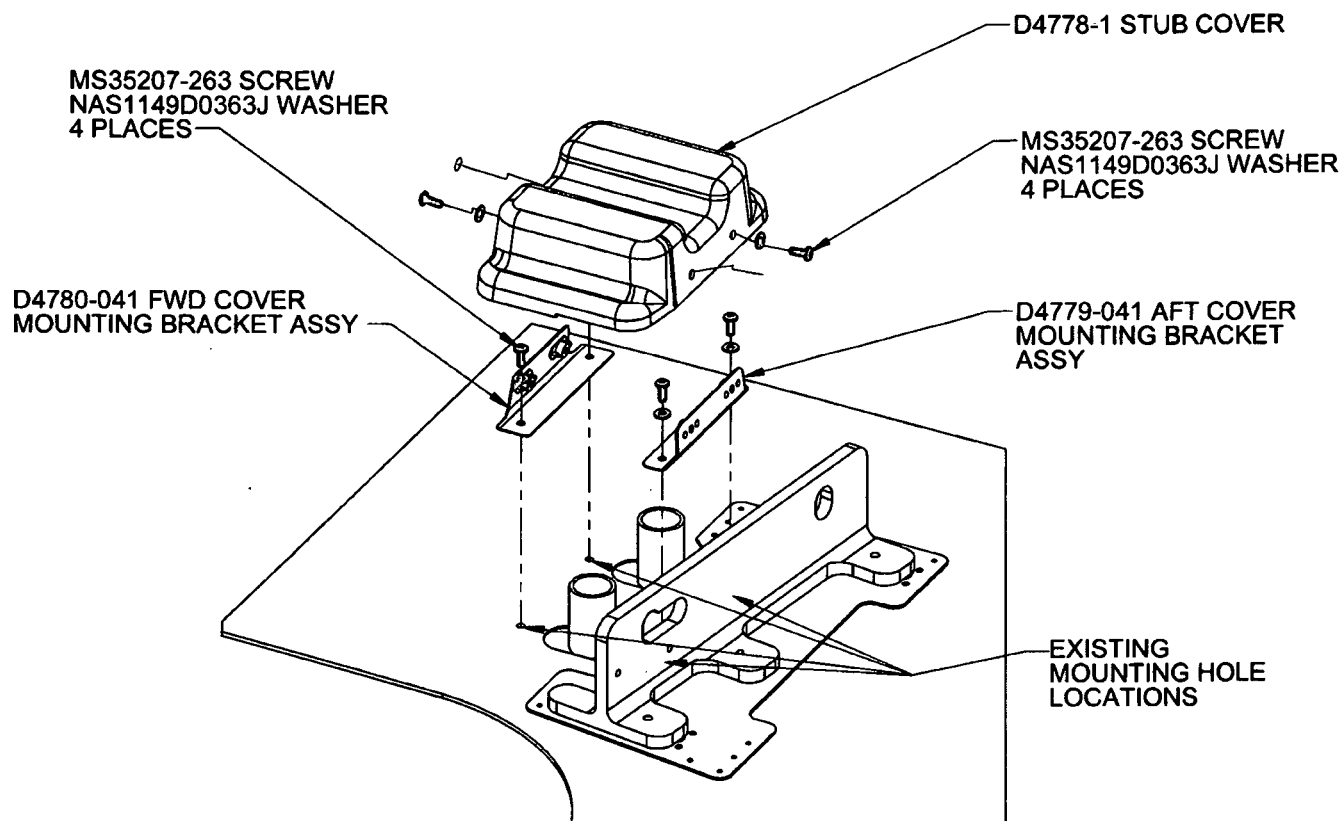


FIGURE 1: PEDAL COVER INSTALLATION

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9645	SHEET 2 OF 2
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	STUB COVER INSTALLATION	NTS
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-616 Rev C

REF CANADIAN STC: SH96-10
REF FAA STC: SR00405NY
REF DANISH STC: 27/96 AND 28/96
REF UK CAA STC: 28097
REF DGAC FRANCE STC: 84-SI0995 AND 168-SI0996
REF BRAZILIAN STC: 2013S02-03

REFERENCE ONLY

1.0 PURPOSE:

THE PURPOSE OF THIS SERVICE INSTRUCTION IS TO OUTLINE THE PROCEDURE FOR REPLACING THE D3494-1 STUB COVER WITH THE D4778-1 STUB COVER BY INSTALLING THE DSI 9645-011 KIT. THE D4778-1 COVER IS DESIGNED TO ELIMINATE THE POTENTIAL FOR INTERFERENCE WITH THE PEDAL STUBS ON SOME AIRCRAFT AND WILL BE INCLUDED IN D350-616-011 KITS AT CHG 005 AND LATER.

2.0 INSTALLATION:

- 2.1 FOR EASE OF INSTALLATION, REMOVE THE D3179-041 LITTER TIE DOWN.
- 2.2 REMOVE THE D3494-1 STUB COVER AND HARDWARE, IF REQUIRED.
- 2.3 PICKING UP ON THE SAME MOUNTING HOLES, INSTALL THE FWD (D4780-041) AND AFT (D4779-041) MOUNTING BRACKETS USING MS35207-263 SCREWS (QTY 4) AND NAS1149D0363J WASHERS (QTY 4).
- 2.4 SLIDE THE D4778-1 STUB COVER OVER THE COVER BRACKETS AND FASTEN WITH MS35207-263 SCREWS (QTY 4) AND NAS1149D0363J WASHERS (QTY 4).
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NOTE: IT IS PERMISSABLE TO TRIM THE COVER EDGE, AS REQUIRED, FOR CLEARANCE OVER DECK PLATES

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1	D4779-041	AFT COVER MOUNTING BRACKET ASSY
1	D4780-041	FWD COVER MOUNTING BRACKET ASSY
8	MS35207-263	SCREW
8	NAS1149D0363J	WASHER

4.0 WEIGHT AND BALANCE

INSTALLATION OF THE DSI 9645-011 STUB COVER INSTALLATION HAS NEGLIGIBLE EFFECT ON WEIGHT AND BALANCE.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE #02)

DATE: 13.03.06
CERT. NO.: SH96-10
ISSUE NO.: #2

A	NEW ISSUE	DB	13.03.06
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9645	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STUB COVER INSTALLATION	NTS
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